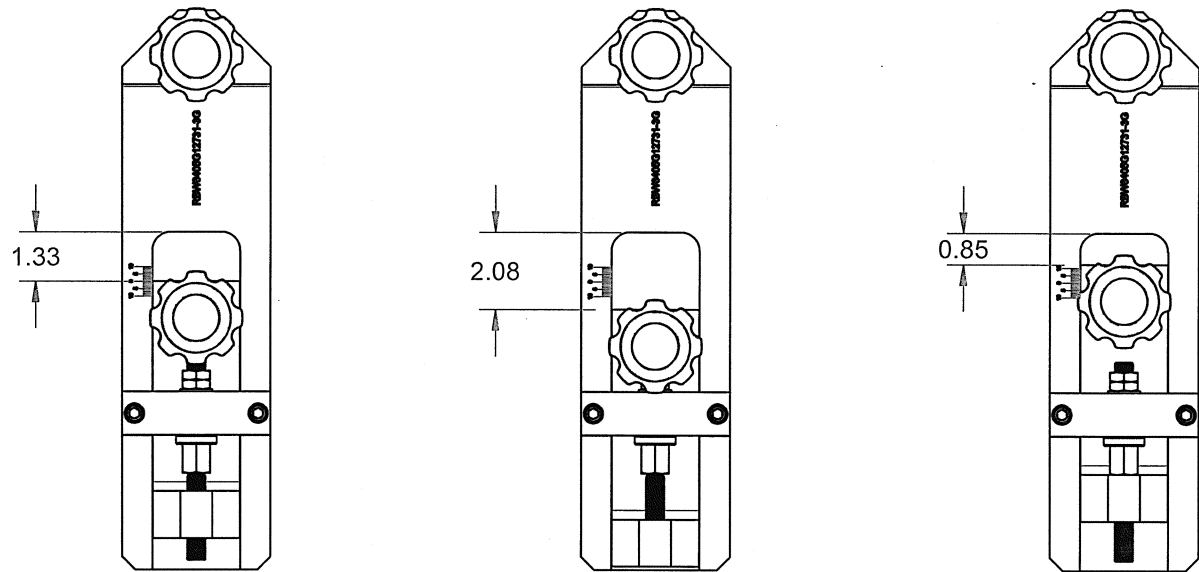


ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6405G12731-3G-1	BASE
-2	1	RBW6405G12731-3G-2	SLIDE
-3	1	RBW6405G12731-3G-3	LOCK
-4	1	RBW6405G12731-3G-4	SCREW
-5	2	RBW6405G12731-3G-5	STAND
6	2	AN316-8R	CAD. PLATED STEEL JAM NUT 1/2"-20 X 1/4" HT.
7	6	NAS1149F0432P	CAD. PLATED STEEL WASHER 0.265" ID. X 0.500" OD. X 0.032" THK.
8	1	NAS1149F0863P	CAD. PLATED STEEL WASHER 0.515" ID X 0.875" OD. X 0.063" THK.
9	6	NAS1351-4-10P	CAD. PLATED STEEL SOCKET HEAD CAP SCREW 1/4"-28 X 5/8" LG.
10	2	NAS1351-5-28P	CAD. PLATED STEEL SOCKET HEAD CAP SCREW 5/16"-24 X 1-3/4" LG.
11	2	McMaster#5532T44 OR EQUIV.	PLASTIC ROUND KNOB 3/8"-16 X 1/2" THREAD DP. X 2-1/2" HEAD DIA.



ZERO POSITION

FULLY OPENED

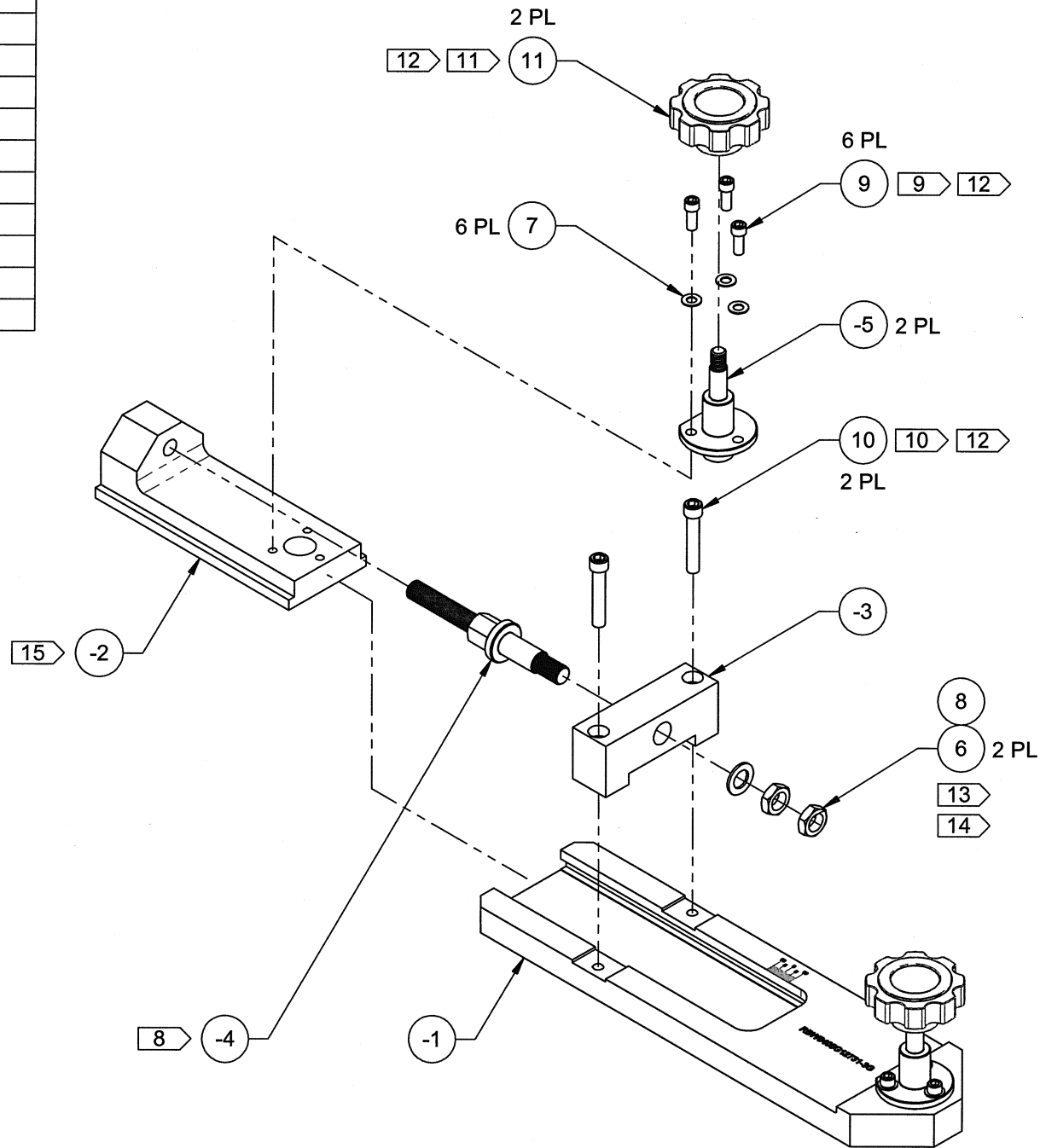
FULLY CLOSED

RBW6405G12731-3G T/R DAMPER ELASTOMER EXTENSION AND RETRACTION

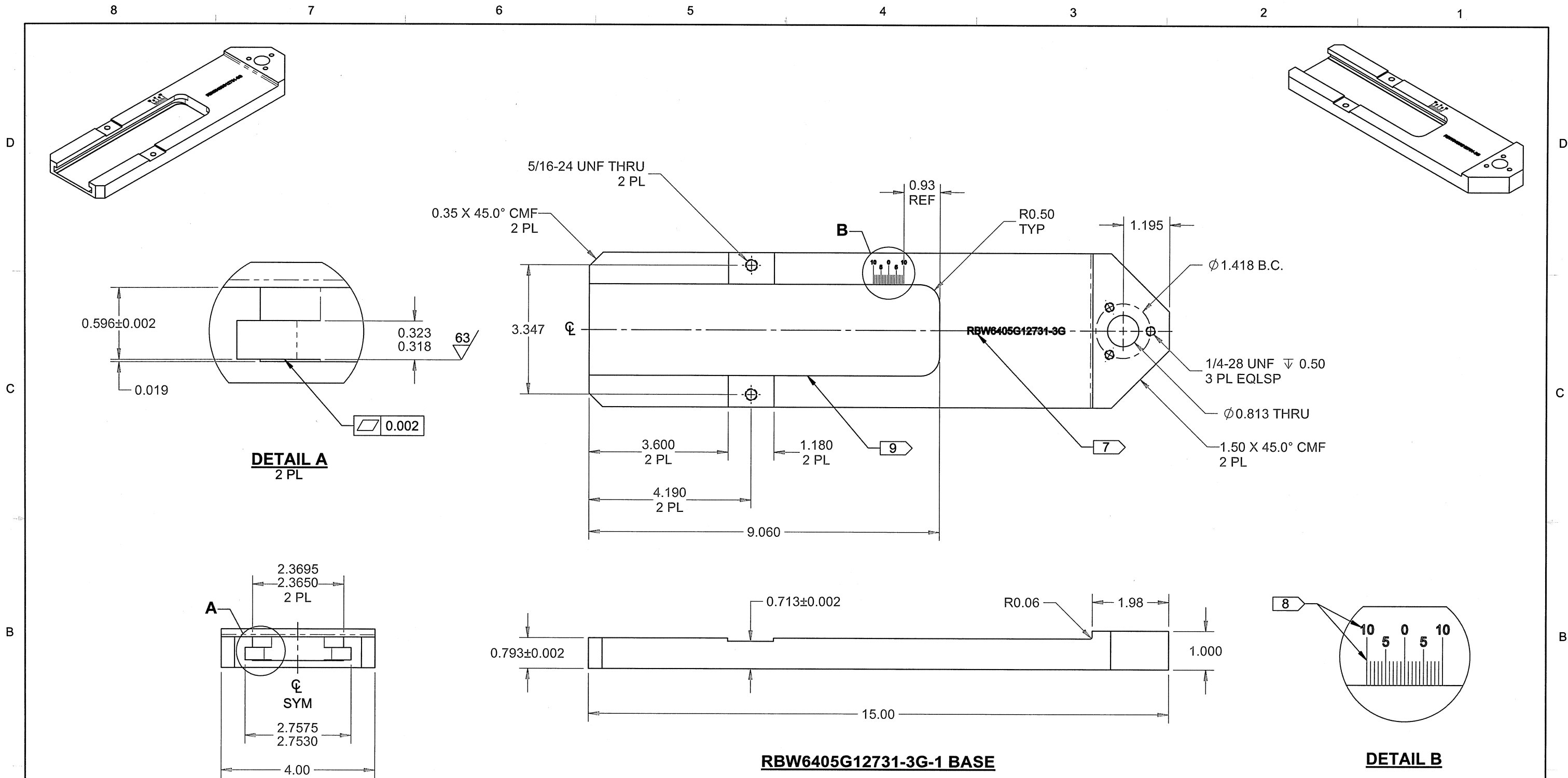
16

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY GREASE MIL-PRF-23827 TYPE II ON THREADS OF ITEM -4
- 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 9 THEN ASSEMBLE WITH ITEMS -1 AND -2, AND REMOVE EXCESS
- 10) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 10 THEN ASSEMBLE WITH ITEM -1, AND REMOVE EXCESS
- 11) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 11 THEN ASSEMBLE WITH ITEM -5, AND REMOVE EXCESS
- 12) INSTALL ITEMS 9, 10, AND 11 HAND TIGHT
- 13) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 6 THEN ASSEMBLE WITH ITEM -4, AND REMOVE EXCESS
- 14) TORQUE ITEM 6 TO 24-34 FT-LBS (290-410 IN-LBS)
- 15) ITEM -2 MUST SLIDE FREELY ALONG ITEM -1 WHEN ROTATING ITEM -4
- 16) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



A	NEW ISSUE	19-849	KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6405G12731-3G	SHEET 1 OF 6
APPROVED		TITLE	SCALE
		T/R DAMPER ELASTOMER EXTENSION AND RETRACTION	NTS
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- NOTES:
- 1) MATERIAL: 4140 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBW6405G12731-3G", AS SHOWN
 - 8) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN, THEN FILL WITH WHITE INK
 - 9) DO NOT REMOVE SHARP EDGE WHERE SHOWN

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6405G12731-3G	SHEET 2 OF 6
APPROVED		TITLE	SCALE
		T/R DAMPER ELASTOMER EXTENSION AND RETRACTION	NTS
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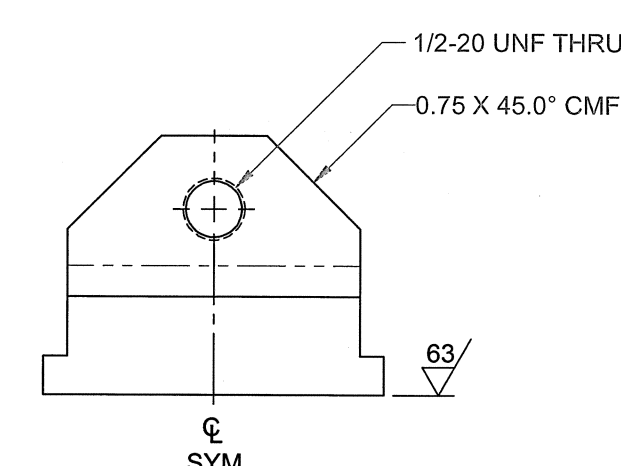
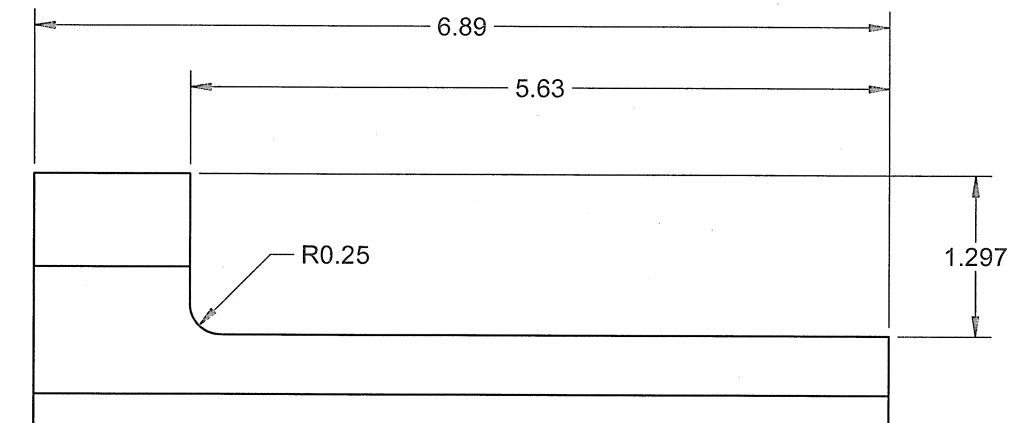
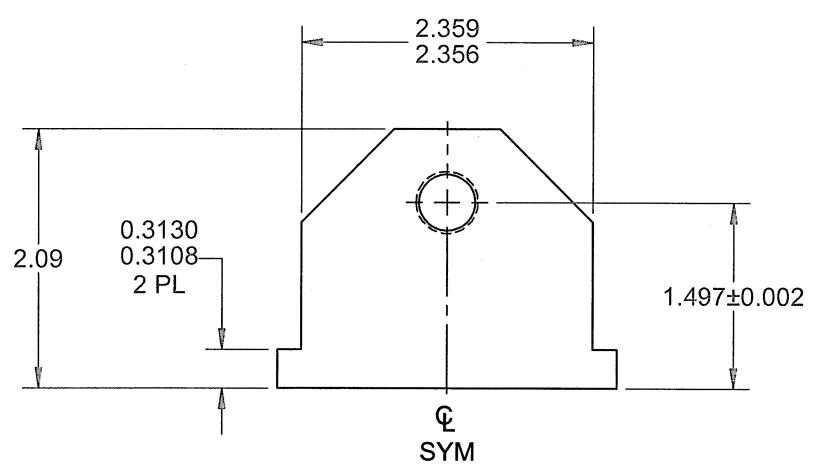
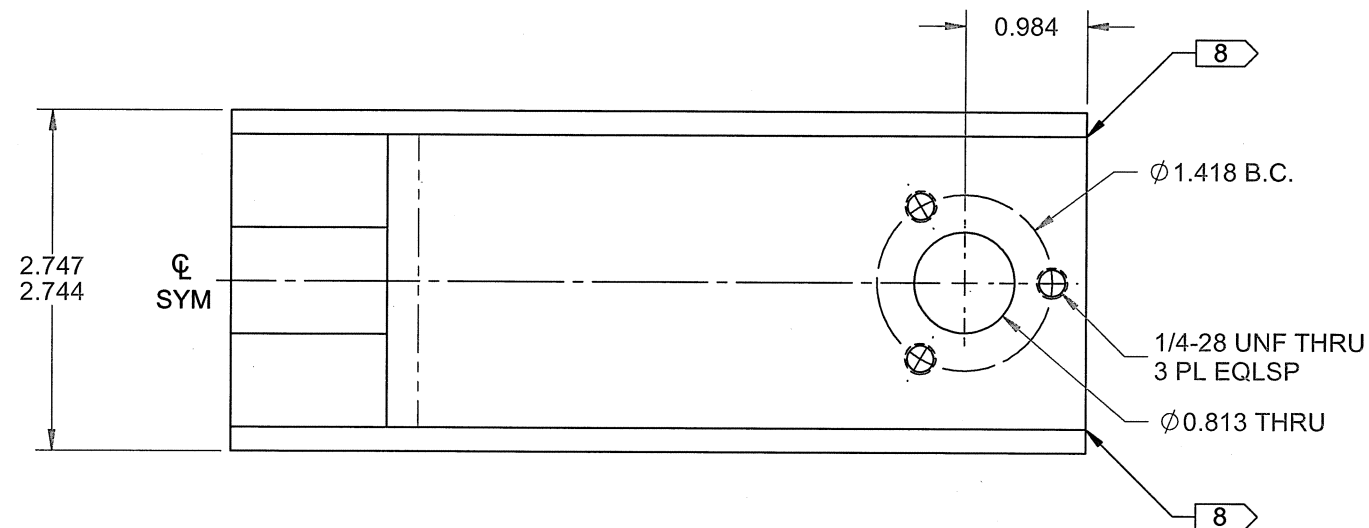
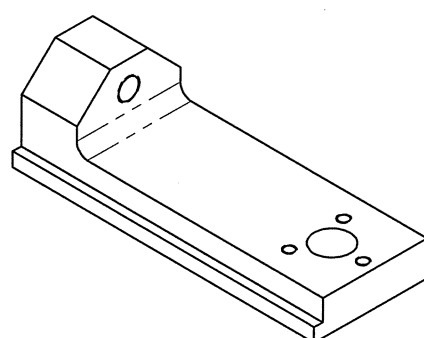
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D

C

B

A

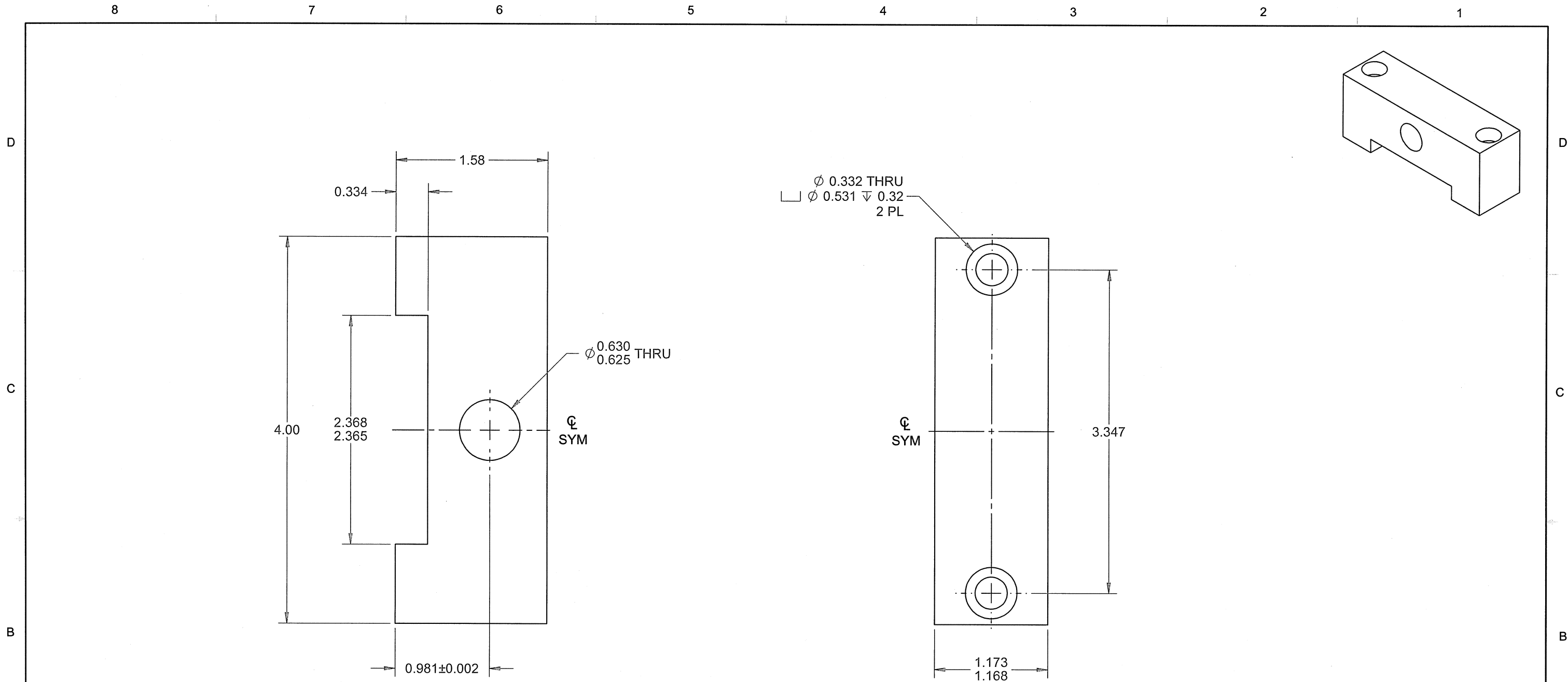


RBW6405G12731-3G-2 SLIDE

- NOTES:
- 1) MATERIAL: 4140 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A
 - 8) DO NOT REMOVE SHARP EDGE WHERE SHOWN

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6405G12731-3G	SHEET 3 OF 6
APPROVED		TITLE	SCALE
		T/R DAMPER ELASTOMER	NTS
		EXTENSION AND RETRACTION	
DATE	2019-08-13	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

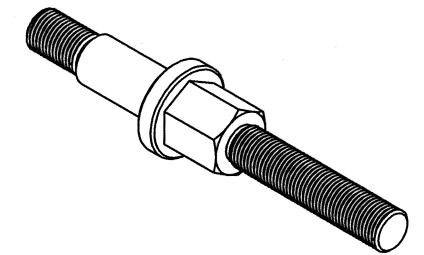
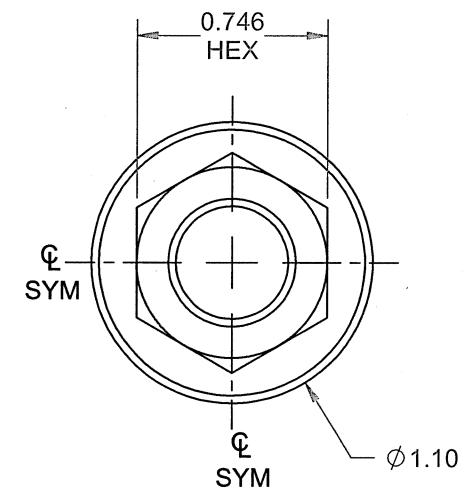
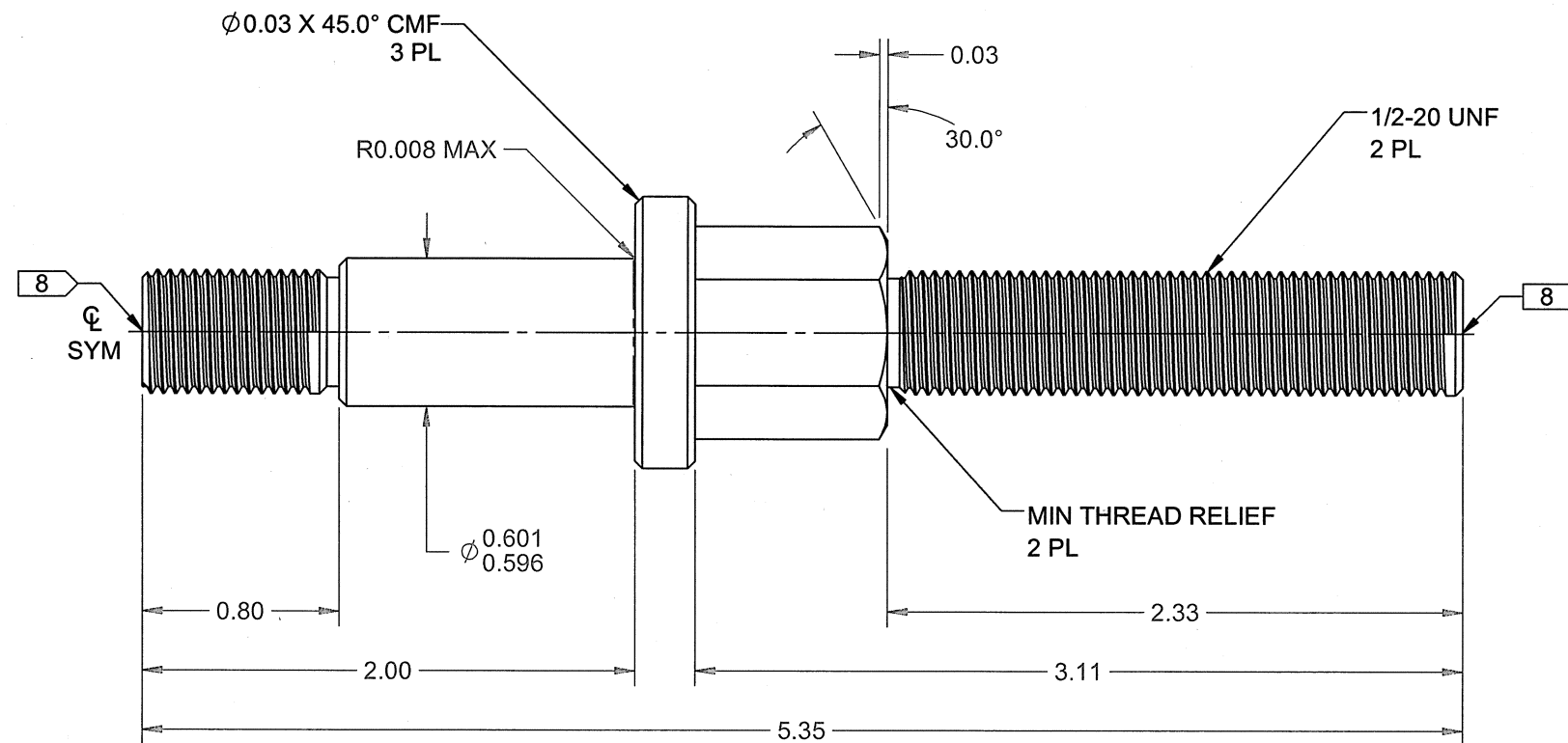


RBW6405G12731-3G-3 LOCK

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6405G12731-3G	SHEET 4 OF 6
APPROVED	<i>Wf</i>	TITLE	SCALE
		T/R DAMPER ELASTOMER EXTENSION AND RETRACTION	NTS
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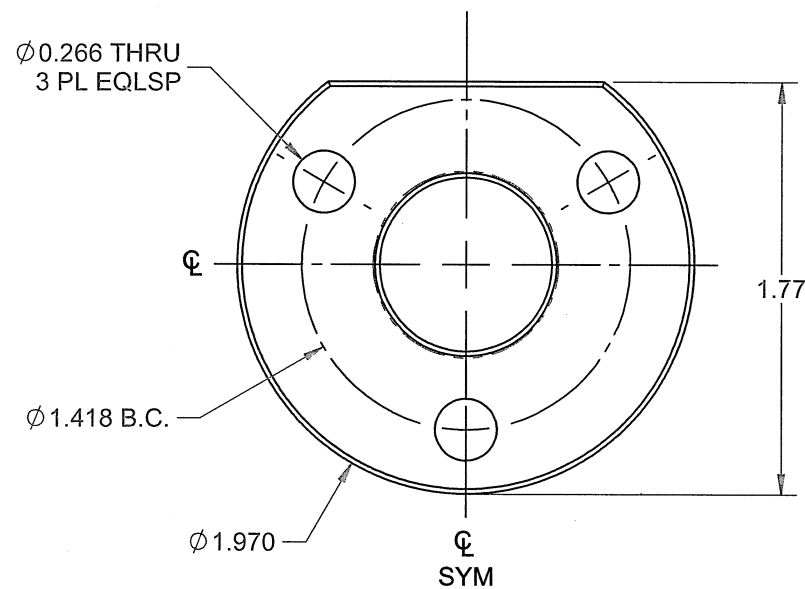


RBW6405G12731-3G-4 SCREW

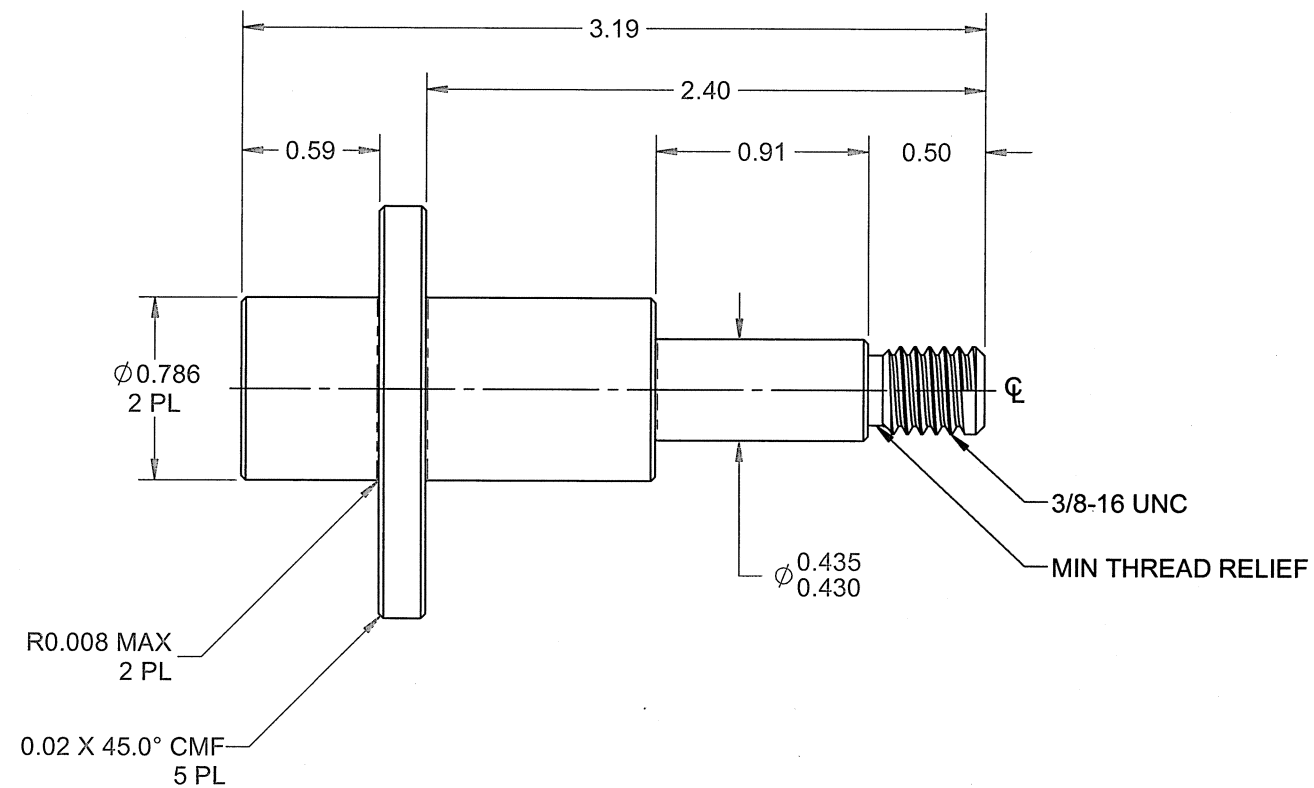
NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6405G12731-3G	SHEET 5 OF 6
APPROVED		TITLE	SCALE
		T/R DAMPER ELASTOMER EXTENSION AND RETRACTION	NTS
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RBW6405G12731-3G-5 STAND



- NOTES:
- 1) MATERIAL: 4140 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = ± 0.1 " / $\pm 1^\circ$
X.XX = ± 0.01 " / $\pm 0.5^\circ$
X.XXX = ± 0.005 " / $\pm 0.1^\circ$
X.XXXX = ± 0.0005 " / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6405G12731-3G	SHEET 6 OF 6
APPROVED		TITLE	SCALE
		T/R DAMPER ELASTOMER EXTENSION AND RETRACTION	NTS
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